

Work Order ID 59773

Friday, June 11, 2010 11:39:40 AM



Page 1

Item ID: D3393-1

Accept



Setup Start



Revision ID:

Item Name: Battery Lock Casing

Stop



Start Date: 6/10/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 10-6-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.500" x 1.500" x 3.125" long

MW 10/06/10

10 

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1

☐

Deburr

MW 10/06/10

10 

120

0.00



QC2- Inspect parts off machine FAI/FAIB


QC

Memo

0.00

Quality Control

MW 10/06/10

10 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59773

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Page 2

Item ID: D3393-1

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Required Date: 6/25/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

8/10/06/17



QC

Memo

0.00

Quality Control

10

10

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml

10

06

17

10x

150

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

BR 10-9-10

10

START TIME:

7:25

OVEN TEMPERATURE:

320° FINISH TIME:

7:55

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Friday, June 11, 2010 11:39:40 AM

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Setup Start

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Stop

**Insp.
Stamp**

0.00

[illegible]

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: 6A

0.00

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00


[illegible]

QC

Memo

0.00

Quality Control

10/09/13 
CL 10/9/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 11, 2010 11:39:45 AM

Page 1

Work Order ID: 59773

Parent Item: D3393-1

Parent Item Name: Battery Lock Casing

Comments: IPP A 05.02.18 New issue KJ/JLM

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	16.0262	0.2708	2.850526			



6061-T6 Bar 1.50 x 1.50



Location

Loc Qty

Loc Code

MAT10

16.0262

107244

1

107432

15.0262

mw
10/06/10

2.850

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign- & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59773
Description: Battery Lock Casing		Part Number:	D3393-1
Inspection Dwg: D3393	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+0.010/-0.000	Ø0.750	✓			
0.625	+0.010/-0.000	0.627	✓			
Ø1.250	+/-0.010	Ø1.252	✓			
1.088	+/-0.010	1.084	✓			
Ø0.734	+/-0.010	Ø0.736	✓			
2.658	+/-0.010	2.653	✓			
1.550	+/-0.010	1.551	✓			
0.125 x 45°	+/-0.010 x 0.5°	0.125 x 45°	✓			
1.50	+/-0.030	1.490	✓			
0.750	+/-0.010	0.750	✓			
Ø1.050	+/-0.010	Ø1.055	✓			
Ø1.000	+/-0.010	Ø1.000	✓			
0.338	+/-0.010	0.340	✓			
0.563	+/-0.010	0.564	✓			
0.100	+0.000/-0.010	0.096	✓			
3.00	+/-0.030	3.00	✓			
1.500	+/-0.010	1.500	✓			
0.375	+/-0.010	0.373	✓			
1.25	+/-0.030	1.247	✓			
0.125	+/-0.010	0.125	✓			
30°	0.5°	30°	✓			

Measured by:	m5
Date:	10/06/17

Audited by:	JS
Date:	10/06/17

Prototype Approval:	N/A
Date:	N/A

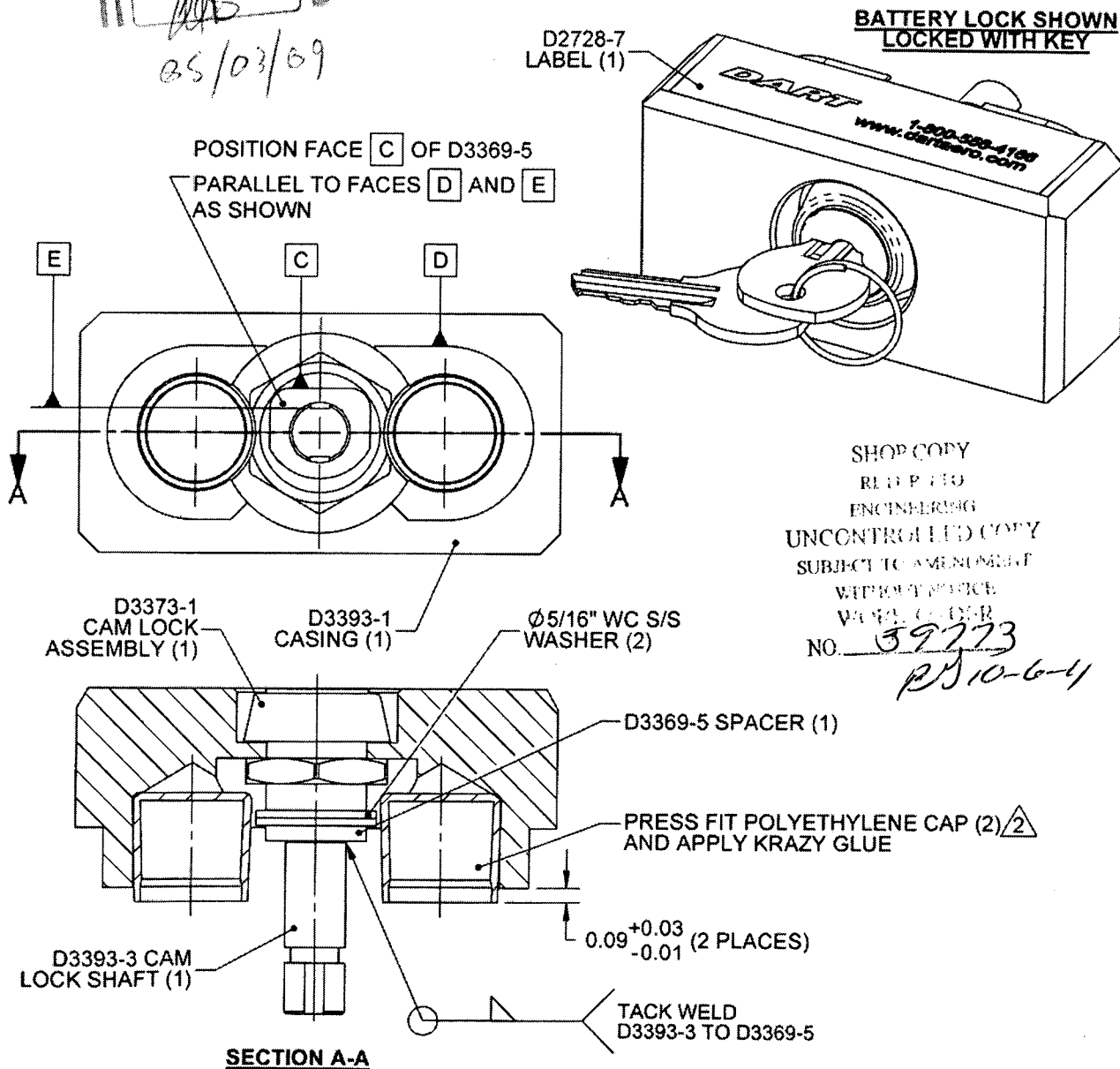
Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	
B	08.11.28	Tolerances revised	KJ/EC	

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

05/03/09

**D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

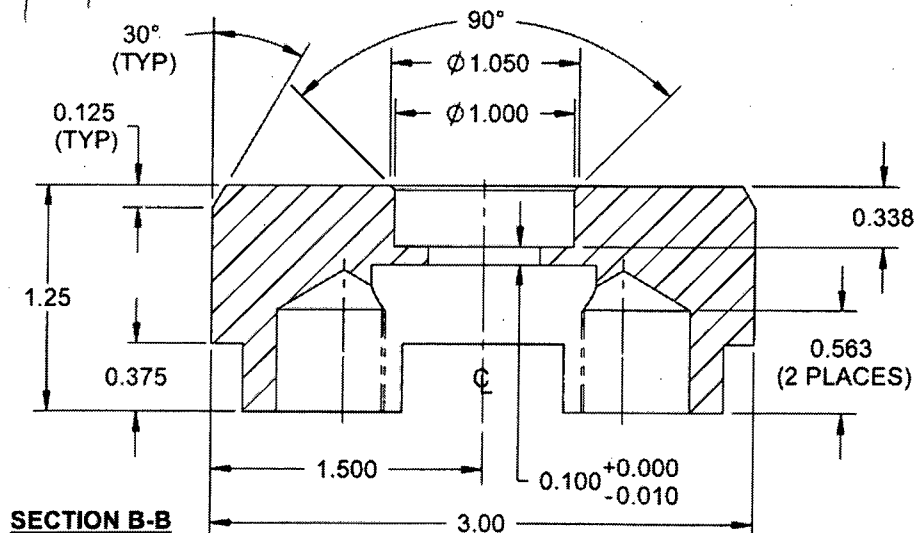
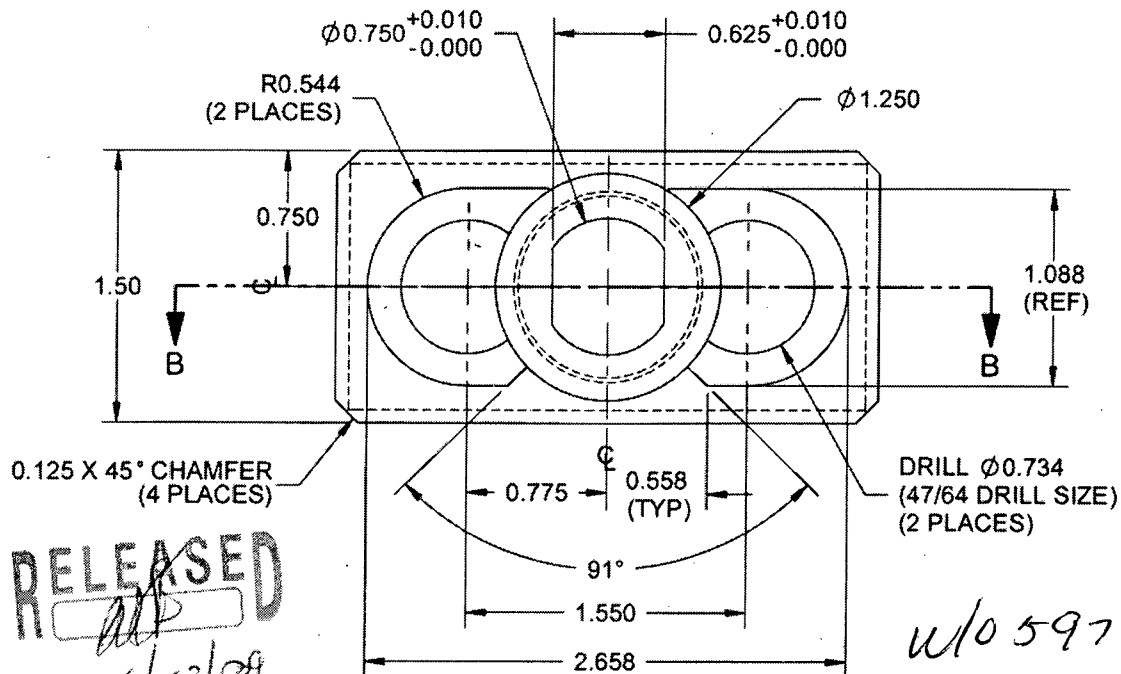
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 17	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 1:1

**D3393-1 CASING****NOTES:**

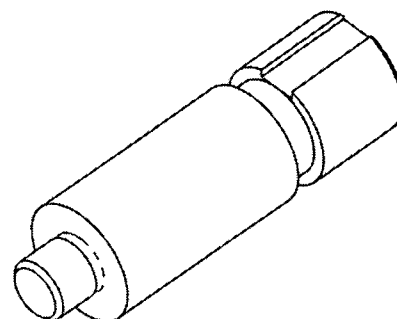
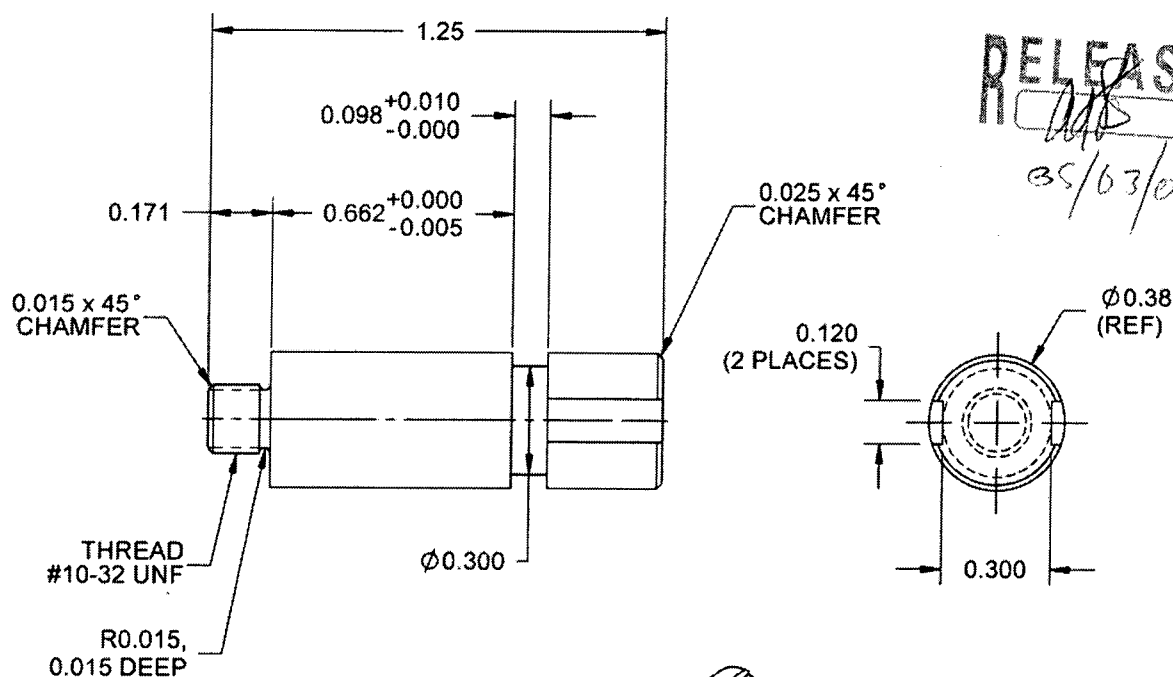
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TF</i>	APPROVED <i>MD</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



W/0 59773

D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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